

Claims:

1. A plate of wood material, wherein wood fibres or wood chips or flakes and synthetic particles or fibres, respectively, are compressed to a panel by a heat compression process, a portion of the wood chips or fibres are substituted by a milled or fibrillated agglomerate of mixed synthetics of waste material from waste removal and the particle size of wood chips or flakes or fibres on one side and that of the milled agglomerate on the other side, is approximately equal.
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- 10 2. The plate of claim 1, wherein the contents of milled or fibrillated agglomerate is up to 150 % referred to the mass of wood chips or flakes or wood fibres atro.
3. The plate of claim 1, wherein the contents of milled or fibrillated agglomerate is above 150 % referred to the mass of wood chips or flakes or fibres atro.
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4. The plate of claim 1, wherein the particle size is 0,05 to 2,0 mm.
5. The plate of claim 4, wherein the particle size is smaller than 1,0 mm.
- 20 6. The plate of claim 1, wherein the content of milled agglomerate of a low melting pure plastic fraction from collection systems of waste removal is added.
7. The plate of claim 6, wherein the content of added milled pure fraction plastic agglomerate is up to approx. 100 % referred to the contents of milled or fibrillated agglomerate of mixed plastics.
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8. The plate of claim 6 or 7, wherein the agglomerate of pure fraction plastics is essentially of remains of synthetic sheets or films.

9. The plate of claim 1, wherein it consists of at least 2 layers, a first layer being composed of wood flakes or fibres, milled or fibrillated agglomerate of mixed plastics and a binding means and the second being composed of wood flakes or fibres, milled or fibrillated agglomerate of pure fraction plastics and binding means, the layers being heat-compressed to a plate.
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10. A method for the manufacture of a wood flake panel, wherein plastics particle or fibres are mixed with wood flakes under addition of a binding means and compressed in a heat-compression process to a plate of predetermined thickness, wherein further agglomerate of mixed plastics from waste removal is milled and mixed with wood flakes approx. of the same particle size.
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11. The method of claim 10, wherein the agglomerate is milled in a spice mill.
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12. A method for the manufacture of a wood fibre plate wherein plastic particles or fibres are mixed with wood fibres or flakes under addition of a binding means in a heat-compression process to a predetermined thickness, wherein further agglomerate of mixed plastics from waste removal is fibrillated and mixed with wood fibres.
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13. The method of claim 12, wherein the fibrillating of the agglomerate is carried out by a knife ring flakes.
- 25 14. The method of claim 13, wherein wood flakes together with agglomerate is fibrillated and mixed in a refiner.

15. The method of claim 10, wherein agglomerate of a pure fraction plastics from waste removal is milled, and the milled product is added to the mixture at a predetermined content.
- 5 16. The method of claim 15, wherein the agglomerate is milled at low temperature, for example in a cryo mill.
17. The method of claim 10, wherein during the mixing cold adhesive is added, preferably urea.
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18. The method of claim 17, wherein the mixing is carried out in a glueing drum.
19. The application of milled agglomerate of mixed plastics from waste removal as substitute material for wooden mass in a wood flake or wood fibre plate.

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